

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006051**Date Inspected:** 27-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TOWER COMPONENTS**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Gady Rao, was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) & the weld designations reviewed are as follows:

Bay 11

13M Diaphragm to Skin D Fit-lug; East Tower; Lift 1.
15M Diaphragm to Skin D Fit-lug; East Tower; Lift 1.
18M Diaphragm to Skin D Fit-lug; East Tower; Lift 1.
23M Diaphragm to Skin D Fit-lug; East Tower; Lift 1.
28M Diaphragm to Skin D Fit-lug; East Tower; Lift 1.
33M Diaphragm to Skin D Fit-lug; East Tower; Lift 1.
38M Diaphragm to Skin D Fit-lug; East Tower; Lift 1.
43M Diaphragm to Skin D Fit-lug; East Tower; Lift 1.
47.6M Diaphragm to Skin D Fit-lug; East Tower; Lift 1.
Diaphragm (13M to 47.6M) to Skin D Welds; East Tower; Lift 1.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Bay 10

Stiffener to Skin E; North Tower Skin; Lift 2.

Bay 10

SAW

SAW welding of weld joint SSD1 – FCSA3 – 1B/C – 64B located on PCMK LS3-10 to LS3-61; Lift – 3. Welder is identified as 053673. ZPMC QC is identified as Zhong Huang. The welding variables recorded by QC appeared to comply with the B – T – 2221 – B – U3C - S – 2.

FCAW

1) FCAW welding of welds joint SSD1-FASA3 – 1E/E – 6, 7, 38, 39 located on SKIN – A; LIFT-3. Welders are identified as 066747 / 068919 & 067954 / 06206. ZPMC QC is identified as Liu Liang. The welding variables recorded by QC appeared to comply with the B-T-2332-TC-P5-F.

2) FCAW welding of welds joint SSD1-FASA3 – 1E/E – 58, 59 located on SKIN – A; LIFT-3. Welders are identified as 068087 / 066165. ZPMC QC is identified as Liu Liang. The welding variables recorded by QC appeared to comply with the B-T-2332-TC-P5-F.

SMAW

1) SMAW welding of welds joint WD1-A467 – 33M –4 – 2A, 3A located on PCMK P 1107 to P 202; LIFT-3. Welders are identified as 068924 / 040269. ZPMC QC is identified as Liu Yang. The welding variables recorded by QC appeared to comply with the B-T-3212- TC – U5B -1.

2) SMAW welding of welds joint ND1-A468 – 28M –2 – 1B, 2B located on PCMK P50 to P12; LIFT-3. Welders are identified as 056364 / 040268. ZPMC QC is identified as Liu Yang. The welding variables recorded by QC appeared to comply with the B-T-3212 – TC – U5B - 1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045., who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Rao,Gady	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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